

Work Order ID 84095

84095

Page 1

Wednesday, May 02, 2012 2:42:06 PM

Item ID: D350-636-016

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: P Date: 12-05-12 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3492	C								
D4168	A								
IIN-D350-636	I								

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-016 CHG 002 JB

DAS 16 2-89

HA Col MLS 12-7-24

B84095 RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

0.00

0.00

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section R-R

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168 Detail J

6- Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail K.
SECOND SIDE

8- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole

9- Open up holes of Detail J to 0.297" (total of 2 holes per side) + .201 iplace per side and open holes of detail M section R-R to 0.500" as per dwg D4168

10- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bead left from bending as per QSI 004

A/R Aluminum Rod batch: m120 8541 0 BE 12/05/30

PTO

W/O: 84095		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-016 PAR #: Fault Category: Landing Gear/Skid/Stair NCR: Yes No DQA: Date: 12/09/07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 12/9/7

NCR: 121639		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
12/05/29	9	BLADE FITTING HOLES DO NOT ALIGN WITH BLADE FITTING JIG. HUMAN ERROR/Process. → DRILL HOLES	S 12/05/30 DSL042	Scrap + Destroy And Replne	BE 12/05/29	S 12/05/30 DSL042	S 12/05/30 DSL042	S 12/05/29

Reg. material only.

09/10/12

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Grind welds flush as per Dwg D4168

BE 12/05/30

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

Quality Control

0.00

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

Quality Control

0.00

8/12/15/30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Stop *NS2*

Start Date: 5/2/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side)
as per dwg D4168.2-Open up holes of Detail K to 0.750" (total of 4 holes per side)
as per dwg D4168.3- Open float hole to 0.500" (4 per side) and Run on wearplate holes to .375" 4
per side4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168
(welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: M12022
exp. date: 12-1-48- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004
(welding instructions on sheet 8)A/R Aluminum Rod batch: M120854

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D4168

- CF 12-6-8

CF 12-6-1

7 BE 12-06-04

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
 dwg D4168

12- C'bore section CH-CH

13- Deburr holes

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
 HOLE IN TUBE *****

① SAD 12-06-08

170

170

QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

Memo

0.00

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00				1		12-6-8	
200 *200* Powdercoat Powder Coating 121134	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8:15 OVEN TEMPERATURE: 320 OF FINISH TIME: 8:45	0.00 0.00				1X		12/06/11	
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00				1		12-6-20	

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 Required Date: 5/8/2012 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	HandFinishing					1 R4	0	DP	12/06/20
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								
230		0.00							
230	HandFinishing					1 R4	0	Hand Finishing	
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>1111</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: <u>11121130</u> EXP DATE: <u>14103</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>11110348</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>111114590</u>								

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

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		12/07/23					
250 *250* Packaging Packaging	Pick Kit Memo If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1	0.00 0.00				1			12/07/24 JB
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00		12/07/26					

W/O:		WORK ORDER CHANGES					
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Stop ***NR2***

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270

270

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD350-636-016

Location: _____

PPP rev: _____

0.00

0.00

280

280

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

lx

SP

12-7-26

12/7/30

ME

12-07-26

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Picklist Print

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Work Order ID: 84095

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Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC
11.04.14 ecn11-553 DD verf:EC
per NCR 11-906 DD verf:EC

IPP Rev:B
IPP Rev:C 11.10.18 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3490-1

Manufactured

No

160

Each

61.0000

4

4

D3490-1

Cross Bolt Spacer

**

BB 12/06/04

Location

Loc Qty

Loc Code

LG

2

81976

2

LG001

59

62450

2

74875

4

77042

3

83269

50

4

D3490-3

Manufactured

No

160

Each

62.0000

4

4

D3490-3

Cross Bolt Spacer

**

BB 12/06/04

Location

Loc Qty

Loc Code

LG

2

82016

2

LG001

60

83313

60

4

AN3C34A

Purchased

No

230

Each

47.0000

1

1

AN3C34A

BOLT

**

BB 12/06/25

Location

Loc Qty

Loc Code

ST353

47

116075 ✓

27

117514

20

W/O:		WORK ORDER CHANGES					
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Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Purchased

No

230

Each

190.0000

4

4

AN3C.36A

BOLT

**

7

20

12/06/25

Location

Loc Qty

Loc Code

FG

4

101261

4

ST353

186

116590

0

119083

2

119324

31

121013

6

121167

7

121276

15

121388

75

121389 ✓

50

AN3C37A

Purchased

No

230

Each

217.0000

1

1

AN3C.37A

BOLT

**

1

JB

12/07/24

Location

Loc Qty

Loc Code

ST354

217

116874

11

117010

2

120422

12

120731

17

121068

100

121584

25

121585

50

121585

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Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C42A

Purchased

No

230

Each

52.0000

1

1

**

JB 12/07/24

AN3C42A

BOLT

Location

Loc Qty

Loc Code

ST354

52

106176

1

119673

1

120464

25

121103

25

121103

D3488-042

Manufactured

No

230

Each

19.0000

1

1

**

1 2P 12/06/25

D3488-042

Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP002

19

62003

1

75068

2

77015

1

82258

15

D3492-1

Manufactured

No

230

Each

385.0000

8

8

**

8 2P 12/06/20

D3492-1

Plug

Location

Loc Qty

Loc Code

FP002

242

69531

8

74444

2

76235

4

83259

228

FP-A

143

83098

143

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 02, 2012 2:42:12 PM

Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-3 Manufactured No

230

Each

125.0000

8

8

D3492-3

Plug

**

8

SP

12/06/20

Location

Loc Qty

Loc Code

FP-A

125

81967

5

83099 ✓

120

D3873-1 Manufactured No

230

Each

578.0000

7

7

D3873-1

Bushing

**

7

SP

12/06/25

Location

Loc Qty

Loc Code

ST057

42

79561

42

ST067

536

64760

1

68247

4

73829

19

73830

2

76791 ✓

490

79560

20

D4154-041 Manufactured No

230

Each

0.0000

1

1

D4154-041

Wearplate Assembly

**

1383693

BB 12/06/04

D4170-1 Manufactured No

230

Each

45.0000

4

4

SP

12/06/25

D4170-1

Bushing

**

Location

Loc Qty

Loc Code

LG001

45

71844

5

82043

40

6

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

D4171-1 Manufactured No

230

Each

4.0000

1

1

D4171-1

**

1 (SP) 12/06/25

Bushing

Location

Loc Qty

Loc Code

ST135

82385

4

77008

4

MS21043-3

Purchased

No

230

Each

1,009.000

4

45 CL 12/06/25

MS21043-3

**

5 (SP) 12/06/25

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

88

120693

88

ST301

849

118077

2

118614 ✓

67

118686

30

119758

20

121255

730

NAS1149C0363R

Purchased

No

230

Each

3,234.000

9

9

NAS1149C0363R

**

9 (SP) 12/06/25

Washer

Location

Loc Qty

Loc Code

ST297

3234

114742 ✓

3234

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

208.0000

4

4

*NAS1515H3I *
WASHER

**

4 (2P) 12/06/25

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

168

118686

3

119438

1

120360

15

121243

49

121556 ✓

100

NAS1611-010

Purchased

No

230

Each

258.0000

8

8

NAS1611-010
O-RING

**

8 (2P) 12/06/20

Location

Loc Qty

Loc Code

FP001

258

110915

14

117460

8

118077

1

118612

3

119438

47

121259

10

121415

100

121584

75

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

190.0000

8

8

NAS1611-013

O-RING

**

8

SP

12/06/20

Location

Loc Qty

Loc Code

FP001

121825

190

116582

5

117291

2

117887

53

119623

36

121259

7

121584

87

NAS1149D0863J

Purchased

No

250

Each

265.0000

2

2

NAS1149D0863.I

WASHER

**

JB

Location

Loc Qty

Loc Code

ST298

265

118078

34

119307

31

120308

100

121556

100

120308

D2744

Manufactured

No

110

Each

44.0000

1

1

D2744

Cap

**

BE 12/05/30

Location

Loc Qty

Loc Code

LG002

44

62715

1

78900

12

83412

31

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

19.0000

1

1

D2600-3-BENT

Extrusion Bent

**

BE 12/05/09
\$ 83442 *2

Location

Loc Qty

Loc Code

LG

19

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

82347

2

83305

2

D2743

Manufactured No

160

Each

392.0000

8

8

D2743

Crossbolt Spacer

**

BB 12/06/08

Location

Loc Qty

Loc Code

LG

108

81965

135

83262

183

LG001

284

67766

4

68251

3

73403

64

74445

1

79517

2

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

14.0000

1

1

D2739

**

CF 12.6-1

350 I Beam

Location

Loc Qty

Loc Code

LG

14

72155

1

81508

1

83446

3

83448

5

83548

4

ALS4-1032-225

Purchased

No

230

Each

1,498.000

4

4

AI S4-1032-225

**

4 (28) 12/06/20

Insert

Location

Loc Qty

Loc Code

ST281

1475

108696

146

110768

62

118386

55

118966

68

121269 ✓

1144

ST282

23

120410

10

120451

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A	Purchased	No	230	Each	84.0000	1	1	
AN8C35A						**	1	(28) 12/06/25
BOLT								

Location	Loc Qty	Loc Code
FP002	83	
115960	1	
118286 ✓	32	
121275	50	
ST346	1	
114442	0	
115188	0	
115960	1	

AN6C44A	Purchased	No	230	Each	144.0000	4	4	
AN6C44A						**	4	(28) 12/06/20
BOLT								

Location	Loc Qty	Loc Code
FG 121440 ✓	2	
103964	2	
ST343	142	
121013	11	
121167	81	
121440	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

117.0000

1

1

MS21083C8

NUT

**

1

21

12/06/25

Location

Loc Qty

Loc Code

304

95

121185 ✓

45

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

17

121524

17

D3631-1

Manufactured

No

230

Each

467.0000

8

8

D3631-1

Washer

**

8

SP

12/06/20

Location

Loc Qty

Loc Code

FG

452

81874

52

83588 ✓

400

ST072

15

68062

2

75548

13

AN960C10L

✗

NAS1149C0332

Purchased

No

230

Each

0.0000

4

4

***AN960C10I ***

washer

**

4

SP

12/06/20

122063 ✓

Wednesday, May 02, 2012 2:42:14 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No

230

Each

250.0000

8

8

D2745

**

8

(2P)

12/06/20

Bushing

Location

Loc Qty

Loc Code

FP

6

79518

6

FP001

244

69529

1

76142

1

81964

104

83260 ✓

138

NAS1149C0832R

Purchased

No

230

Each

273.0000

1

1

NAS1149C0832R

**

1

(2P)

12/06/25

WASHER

Location

Loc Qty

Loc Code

ST297

273

114915 ✓

273

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Wednesday, May 02, 2012 2:42:14 PM

Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

395.0000

4

4

AN3C6A

BOLT

**

4

(24)

12/06/26

Location

Loc Qty

Loc Code

FP001

121682 ✓
111982

1

1

ST351

394

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

302

MS21043-6

Purchased

No

230

Each

686.0000

4

4

MS21043-6

NUT

**

4

(24)

12/06/20

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

666

117887

6

118384 ✓

160

120308

500

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Wednesday, May 02, 2012 2:42:14 PM

Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

41.0000

2

2

**

83097 JB

C

D3493-1

Washer

Location

Loc Qty

Loc Code

ST050

41

70697

2

77573

1

82023

38

MS21083C8

Purchased

No

250

Each

117.0000

2

2

**

2B

12/07/24

MS21083C8

NUT

Location

Loc Qty

Loc Code

304

95

121185

45

121349

50

121349

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

17

121524

17

C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Wednesday, May 02, 2012 2:42:14 PM

Work Order ID: 84095

84095

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

75.0000

2

2

**

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

75

118758

3

121067

2

121167

20

121275

50

D2741

Manufactured

No

250

Each

34.0000

1

1

**

D2741

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

44

71856

1

79516

33

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE
WORK ORDER
NO. 84095 MLC
12/05/31

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2010-09-15

A		NEW ISSUE		SC	10.08.09
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.			
DRAWN	SC	PORT HADLOCK, WA			
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D4168		SHEET 1 OF 11	
APPROVED		TITLE		SCALE	
DE APPR.		350 SKIDTUBE ASSEMBLY		NTS	
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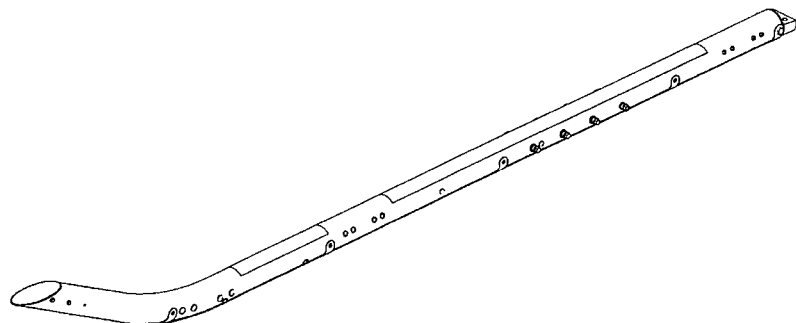
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

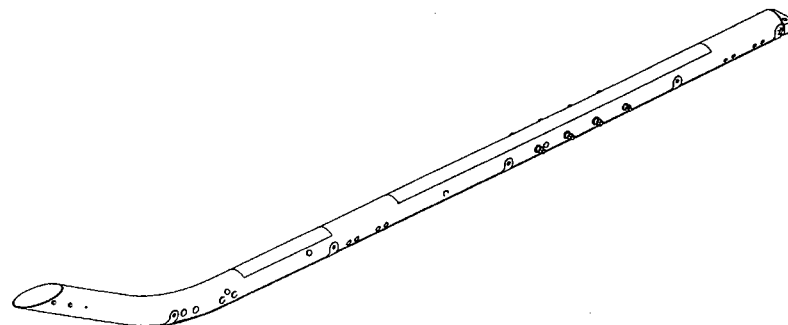
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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04095



D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

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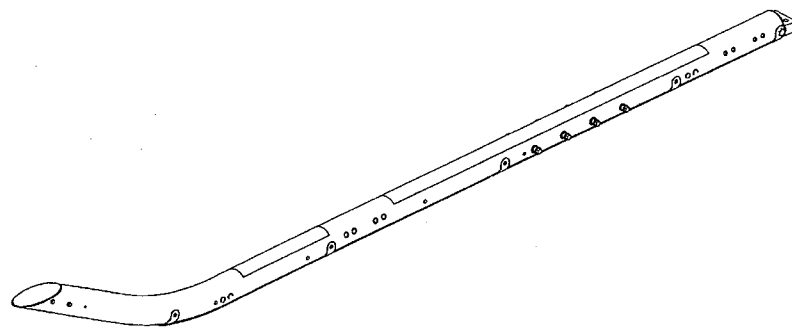
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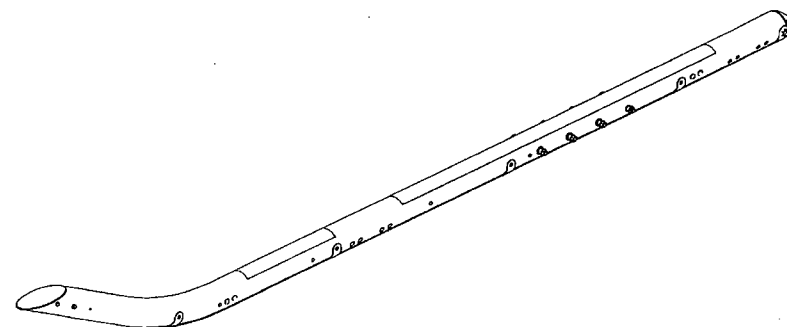
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

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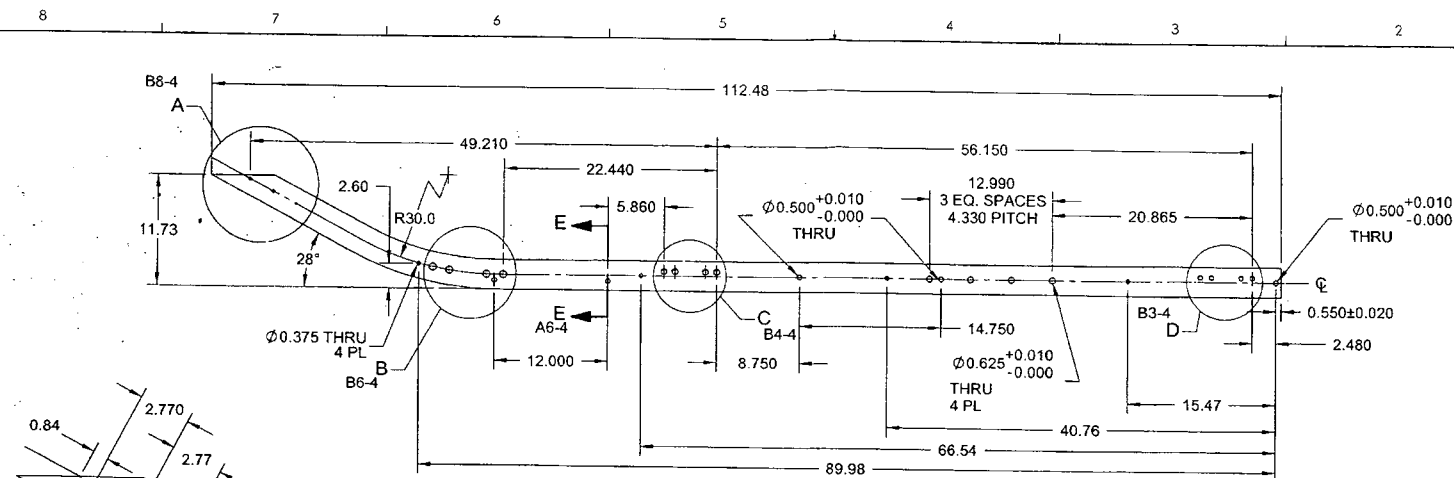
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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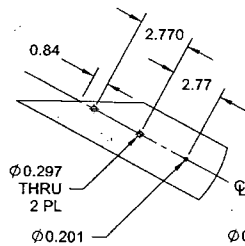
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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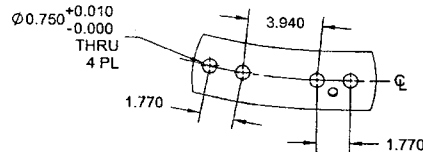
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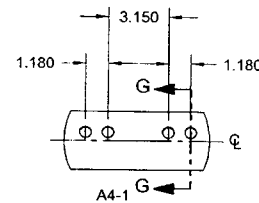
D4168-1 LH SKIDTUBE



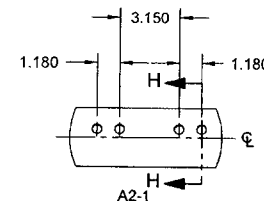
DETAIL A
SCALE 2X



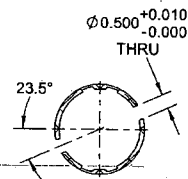
DETAIL B
SCALE 2X



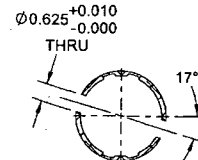
DETAIL C
SCALE 2X



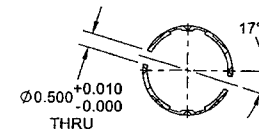
DETAIL D
SCALE 2X



SECTION E-E
SCALE 3X, 4 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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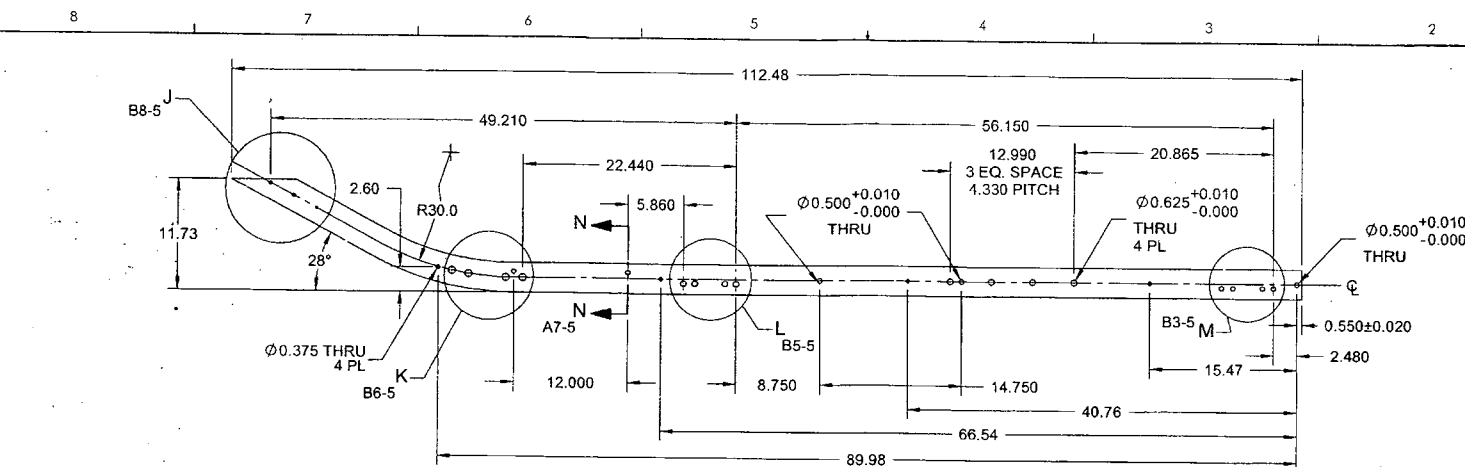
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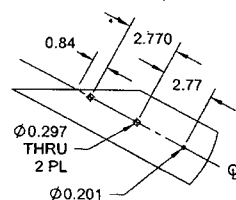
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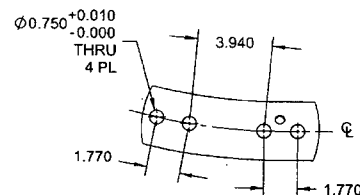


24095

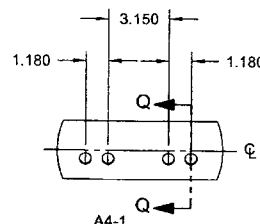
D4168-2 RH SKIDTUBE



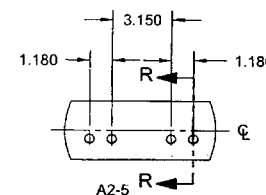
DETAIL J
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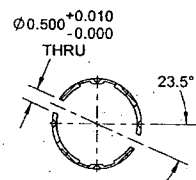
DETAIL K
SCALE 2X



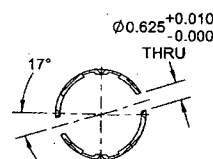
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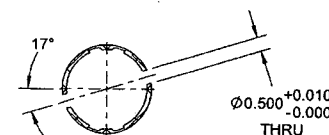
DETAIL M
SCALE 2X



SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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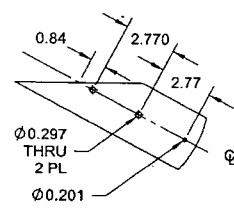
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

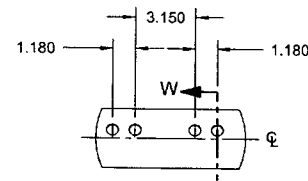
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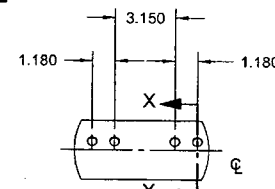
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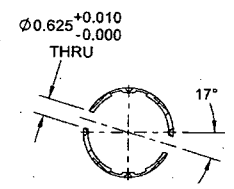
DETAIL S
SCALE 2X
D8-6



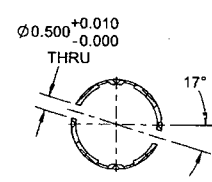
DETAIL T
SCALE 2X
C5-6



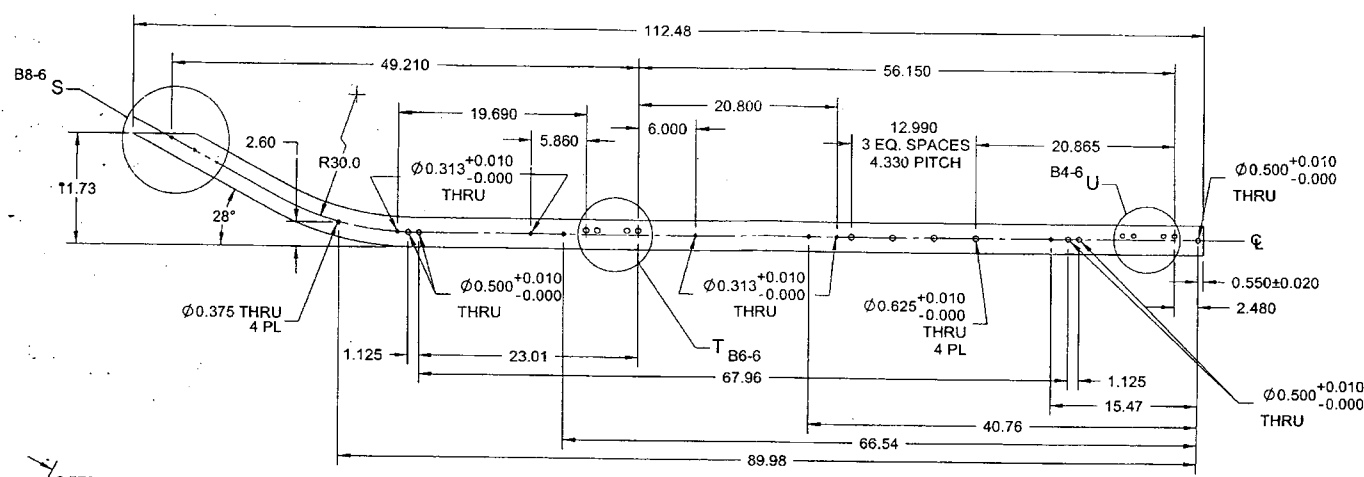
DETAIL U
SCALE 2X
D3-6



SECTION W-W
SCALE 3X, 4 PL
B6-6



SECTION X-X
SCALE 3X, 4 PL
B4-6



D4168-3 LH SKIDTUBE

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

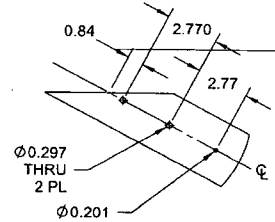
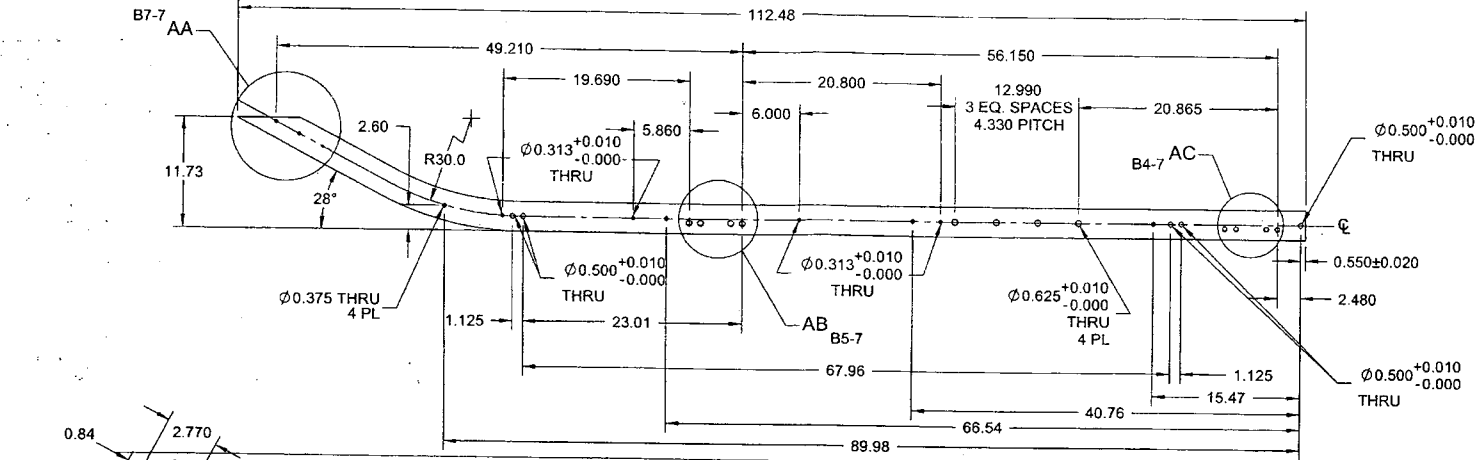
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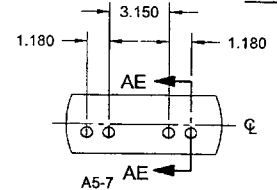
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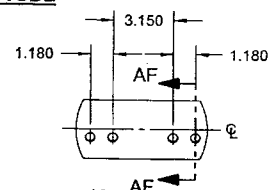
04095



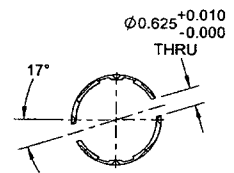
DETAIL AA
D7-7
SCALE 2X



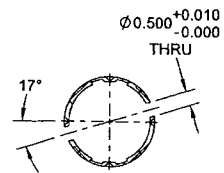
DETAIL AB
C4-7
SCALE 2X



DETAIL AC
D3-7
SCALE 2X



SECTION AE-AE
B6-7
SCALE 3X, 4 PL



SECTION AF-AF
B4-7
SCALE 3X, 4 PL

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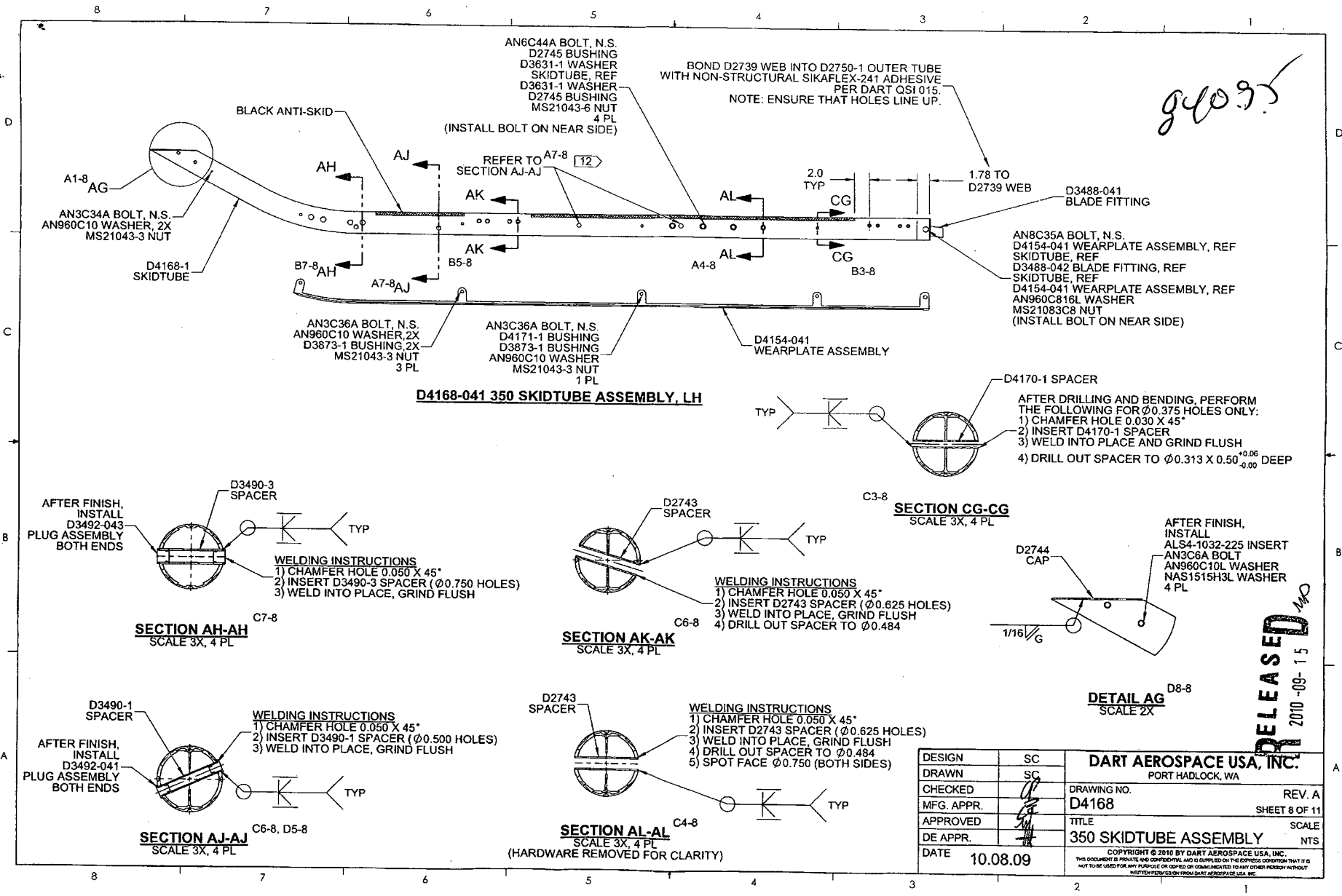
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DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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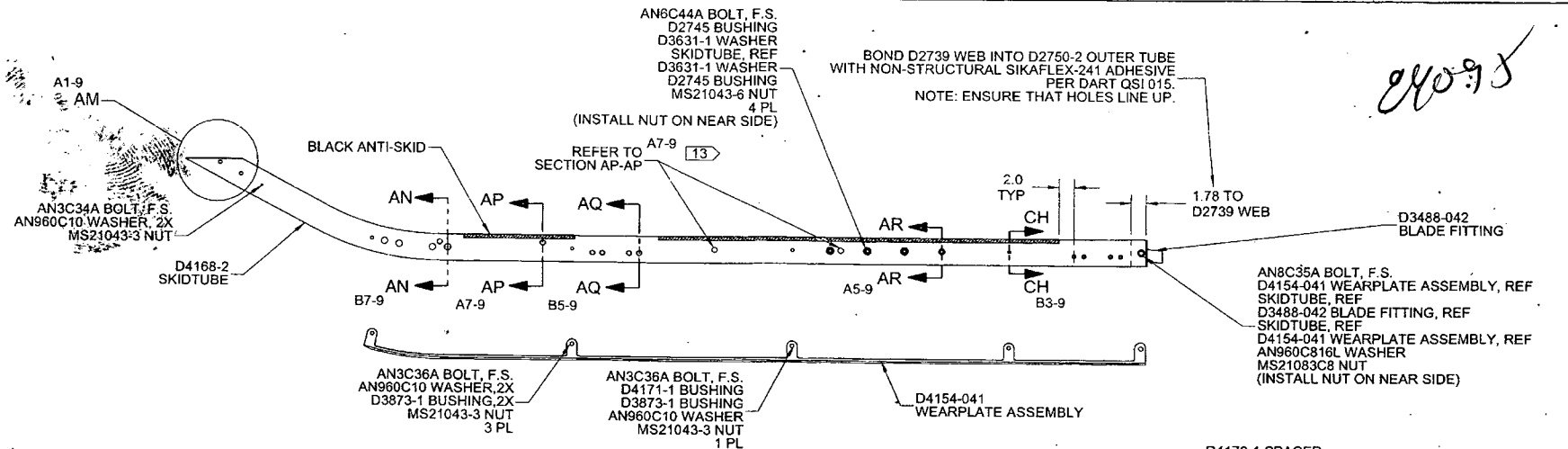
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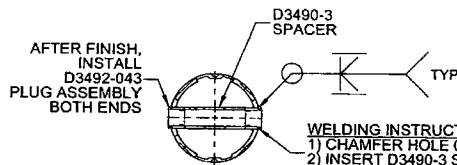
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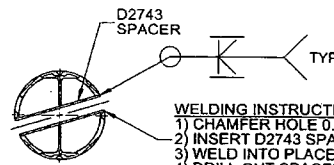


D4168-042 350 SKIDTUBE ASSEMBLY, RH



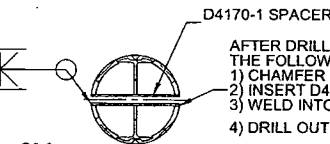
SECTION AN-AN
SCALE 3X, 4 PL

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 X 45°
 - 2) INSERT D3490-3 SPACER (Ø0.750 HOLES)
 - 3) WELD INTO PLACE, GRIND FLUSH



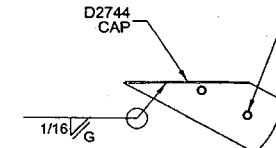
SECTION AQ-AQ
SCALE 3X, 4 PL

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 X 45°
 - 2) INSERT D2743 SPACER (Ø0.625 HOLES)
 - 3) WELD INTO PLACE, GRIND FLUSH
 - 4) DRILL OUT SPACER TO Ø0.484



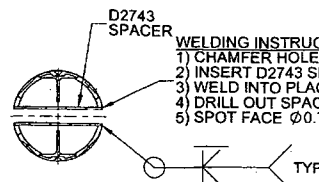
SECTION CH-CH
SCALE 3X, 4 PL

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 X 45°
 - 2) INSERT D4170-1 SPACER
 - 3) WELD INTO PLACE AND GRIND FLUSH
 - 4) DRILL OUT SPACER TO Ø0.313 X 0.50^{+0.06}_{-0.00} DEEP



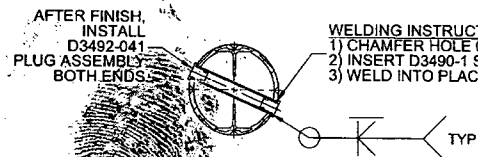
DETAIL AM
SCALE 2X

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 X 45°
 - 2) INSERT D2743 SPACER (Ø0.625 HOLES)
 - 3) WELD INTO PLACE, GRIND FLUSH
 - 4) DRILL OUT SPACER TO Ø0.434
 - 5) SPOT FACE Ø0.750 (BOTH SIDES)



SECTION AR-AR
SCALE 3X, 4 PL

(HARDWARE REMOVED FOR CLARITY)



SECTION AP-AP
SCALE 3X, 4 PL

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 X 45°
 - 2) INSERT D3490-3 SPACER (Ø0.500 HOLES)
 - 3) WELD INTO PLACE, GRIND FLUSH

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DE APPR.	SC	350 SKIDTUBE ASSEMBLY	NTS
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RELEASED
R 2010-09-15

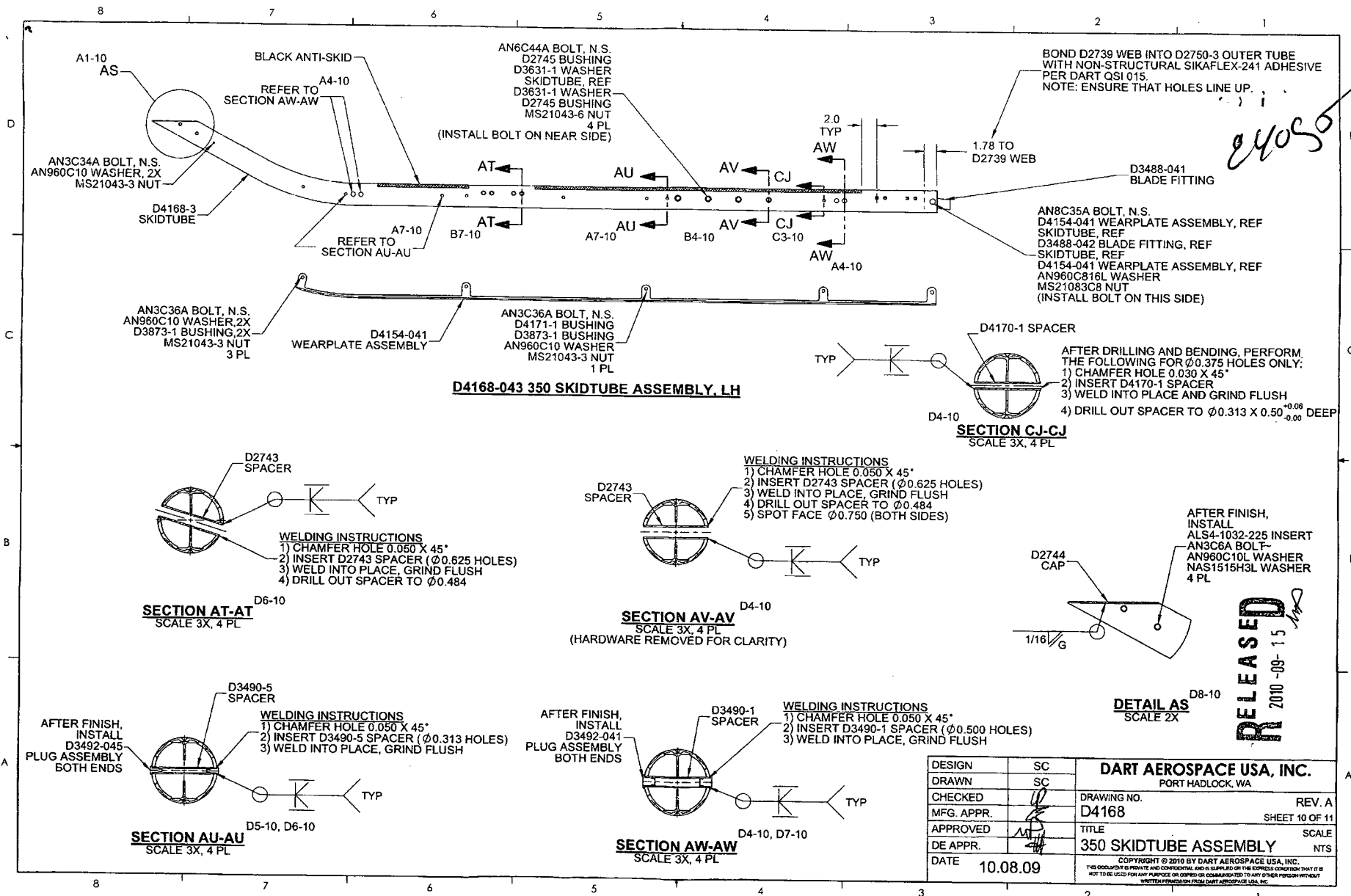
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



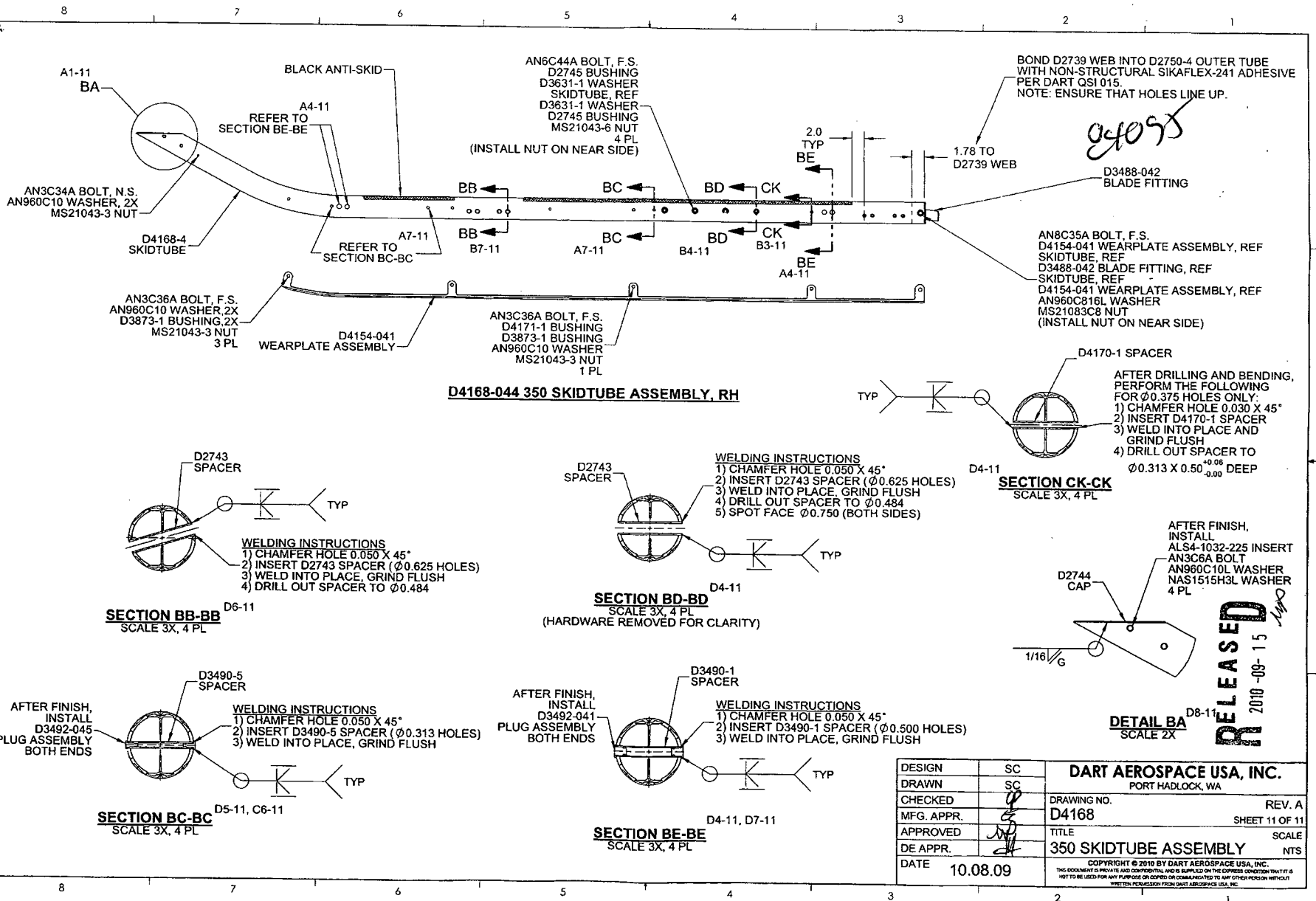
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Change Record

Part Number D350-636-016Page 1 of 1

Description SKIDTUBE STD W/TRAINING WEARPLATES, RH

[illegible]

NO. 294

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 83800
Part number: A350-636-012
Description: Skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Alum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass ☒ fail ☐
pass ☒ fail ☐

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐

Qualifier David Arval Date of Test Coupon 12.05.09
Welder Barday Elliott Date of Test Coupon 12.05.09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld